

Work Order ID 55660

January 27, 2010 9:24:07 AM

Page 1

**PRELIMINARY ISSUE**

Item ID: D4006-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Channel

Start Date: 1/27/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: RP Date: 10-27 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4006	<del>A PRELIM</del> Rev. A 1/10/06-10

100 0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg  
Dwg Rev: PRE  
Prog Rev: Lim

2-Deburr if necessary

B 10-1-27

(4)

110 0.00



QC

Memo

0.00

Quality Control

B 10-1-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

January 27, 2010 9:24:07 AM

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

Run Start

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

**Draw  
Number**

**Draw  
Rev.**

Plan  
Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

120

QC8- Inspect parts - second check

0.00

$$\Rightarrow S_{106,127}$$

0.00

QC

## Memo

## Quality Control

130

Bend as per dwg

0.00

0.00

Brake NC

**Memo**

Brake NC

$R_{10.01.28}$

0.00

150

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

**Memo**

## Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55660

January 27, 2010 9:24:07 AM



Page 3

Item ID: D4006-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Channel

Start Date: 1/27/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160



QC

Quality Control

QC3- Inspect part completeness to step on W/O

Memo

0.00

0.00

10-02-01



170



Packaging

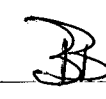
Packaging

Identify as per dwg & Stock Location: \_\_\_\_\_

Memo

0.00

0.00



10/06/14

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/06/15

MR 10-2-19

POSITIVE RECALL

EFFECTIVE 10.21.27

RELEASED

AUTH

DATE 10.06.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 27, 2010 9:24:11 AM

Page 1

Work Order ID: 55660



Parent Item: D4006-3



Parent Item Name: Channel

Start Date: 1/27/10

Required Date: 2/02/10

Comments: IPP rev A 09.12.22 new Issue Prelim EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

22.9696

0.2044

5



18-10-1-27

2024-T3 .063 sheet

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

22.96962419

102942

1.5

105916

1.09

109463

0.00947368

110980

5.4854

111787

12.8847505

19059

2

109463

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

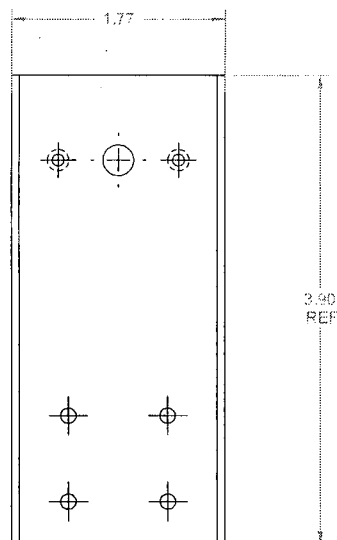
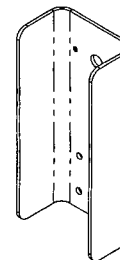
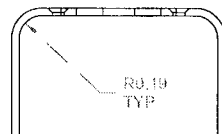


DART AEROSPACE  
PART NUMBER

D4006-3

JOHN CAMERON AVIATION  
PART NUMBER

REF JCA-M47-2-01



See Rev. A

**D4006-3 CHANNEL**

**NOTES:**

- 1) MATERIAL: MADE FROM D4006-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

**PRELIMINARY ISSUE**

09.10.20

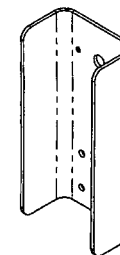
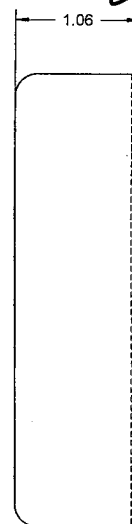
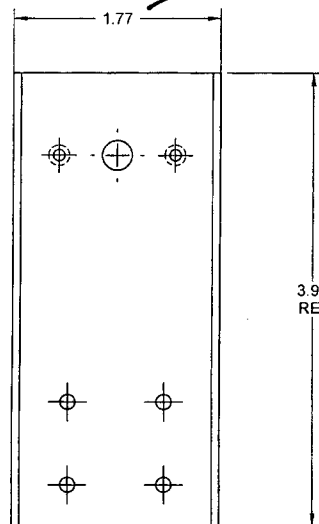
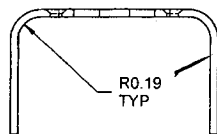
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		<b>D4006</b>	SHEET 4 OF 5
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2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.08 lbs

DESIGN	<b>DART AEROSPACE LTD</b>	
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CHECKED	DRAWING NO.	REV. PA
MFG. APPR.	<b>D4006</b>	SHEETS OF 6
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-3	REF JCA-M47-2-01



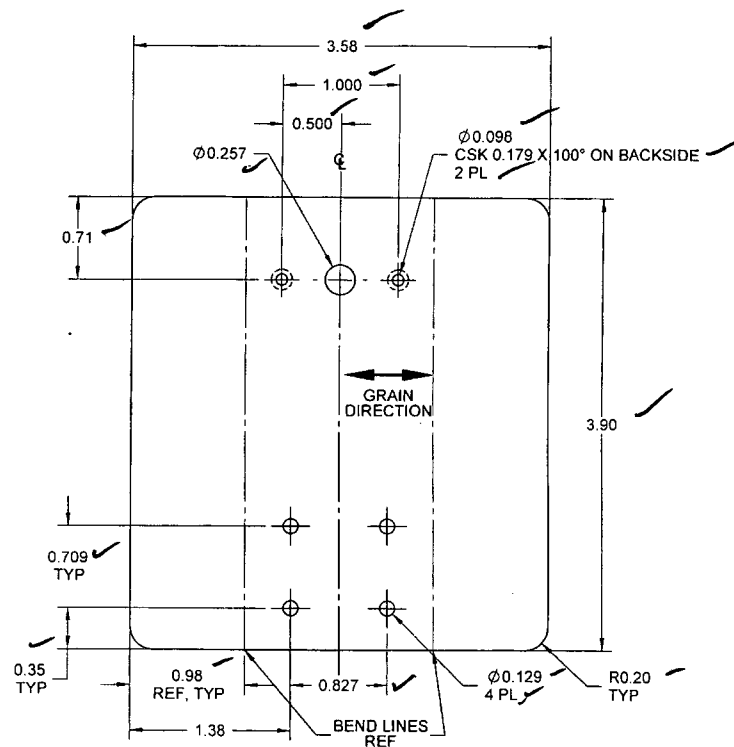
**D4006-3 CHANNEL**

WU 55660

RELEASED  
2010-05-05  
MAD

- NOTES:
- 1) MATERIAL: MADE FROM D4006-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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**D4006-3F FLAT PATTERN**

RELEASED  
2010-05-05

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR AMS 4037 OR ASTM B209  
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
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- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D4006	SHEET 5 OF 6
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